

Date: Tuesday, 7/17/2007 2:01:14 PM  
User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET ASSEMBLY
Job Number	: 33597		
Estimate Number	: 11641		
P.O. Number	: <i>N/A</i>	Part Number	: D2990042
This Issue	: 7/17/2007	S.O. No.	: <i>NA</i>
Prsht Rev.	: NC	Drawing Number	: D2990 REV B
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	: <i>N/A</i>	Drawing Revision	: B
	Type : SMALL /MED FAB	Material	: <i>N/A</i>
Written By	:	Due Date	: 8/10/2007
Checked & Approved By	:	Qty:	7 Um: Each
Comment	: Est B 05.02.22 Revised Step 6 KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D28052	Stop
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 7.0000 Each(s)

STOP

Pick:

Qty Part Number

Description

Batch

1

D2805-2

Stop

*B 29406**\* B 33600 / B34033 x2**ml*

2.0	D29902	Bracket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 7.0000 Each(s)

Bracket

Pick:

Qty Part Number

Description

Batch

1

D2990-2

Bracket

*\* B 33600 x5**( B 33600 / B34033 ) x2**ml*

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D2805-2 into arm as per Dwg D2990

*ml 07/08/27 x7**mf 07-08-*

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

*ml 07/08/28 x7*

5.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat Green Sandtex (Ref. 4.3.5.8) as per QSI 005 4.3

*ml 07/08/29*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 7/17/2007 2:01:14 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 33597

Part Number: D2990042

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7/8/2959

7.0

AN3C16A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 14.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
2	AN3C16A	Bolt	M102552

S9

8.0

MS21042

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 14.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
2	MS21042	Nut	M105211

M105211\*

7/8/2959

9.0

NAS1515H3

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 28.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
4	NAS1515H3	Washer	M105164

4 NAS1515H3

Washer

A/R LPS-3

Corrosion Spray M104929

7/8/2959

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2990  
Assemble as per Dwg D2990.

m107/08/29

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

on 02/08/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/08/31

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 7/17/2007 2:01:14 PM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 33597

Part Number: D2990042

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: QA

*MF 07-08-30*

13.0

QC21

FINAL INSPECTION/W/O RELEASE



(7)

Comment: FINAL INSPECTION/W/O RELEASE

*D 07/08/31*

Job Completion



*6 07-08-31*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

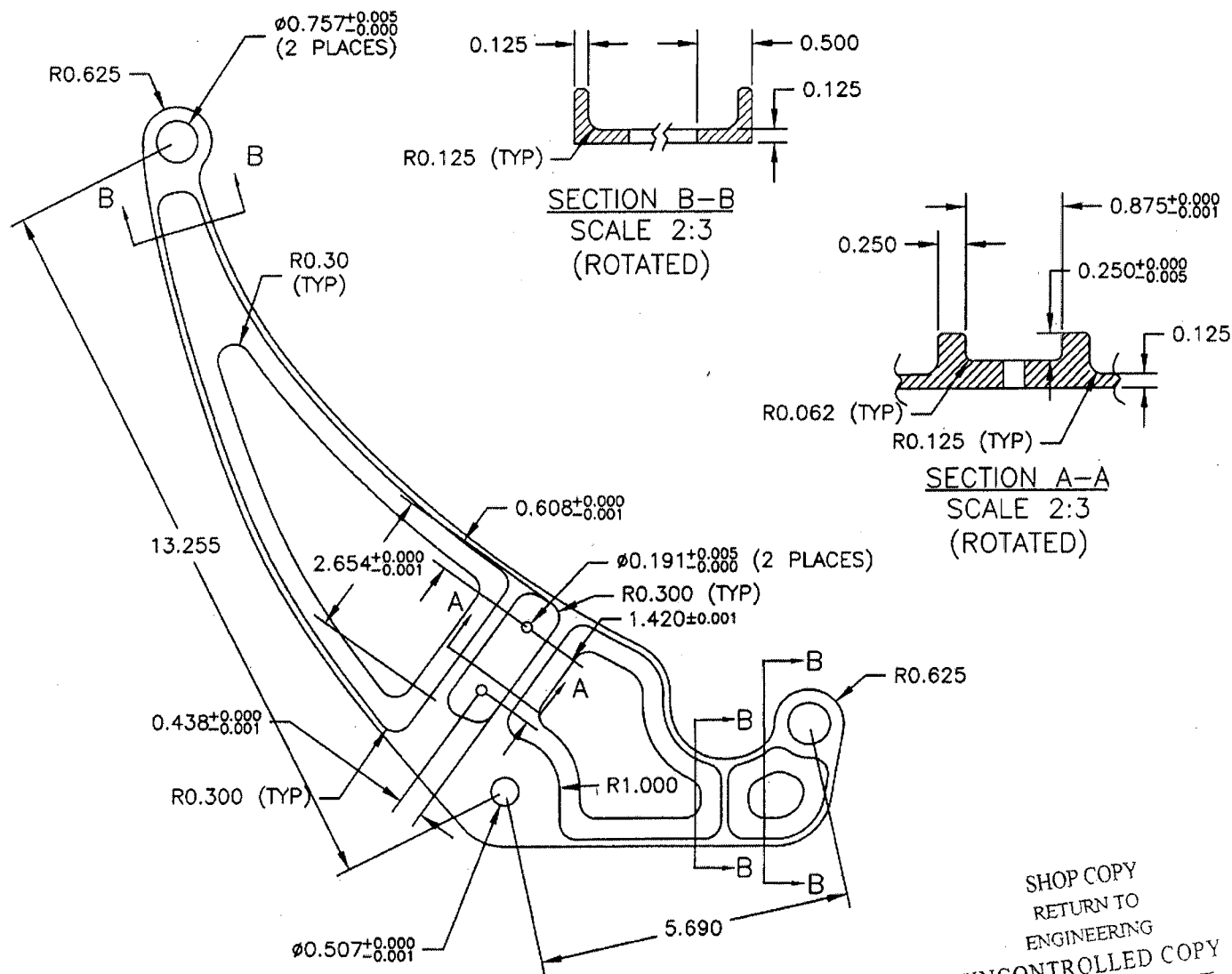
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2990 REV. B SHEET 1 OF 2
DATE	05.01.20	TITLE	STA 129 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE		
B	05.01.20	ADD CUTOUTS & -043/-044		

**RELEASED**05.03.11 *[Signature]***D2990-1 BRACKET (SHOWN). D2990-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2990.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 33597

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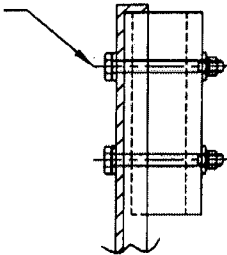


DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2990	REV. B SHEET 2 OF 2
DATE 05.01.21	TITLE STA 129 BRACKET		SCALE 1:3

RELEASED

05.03.11 #

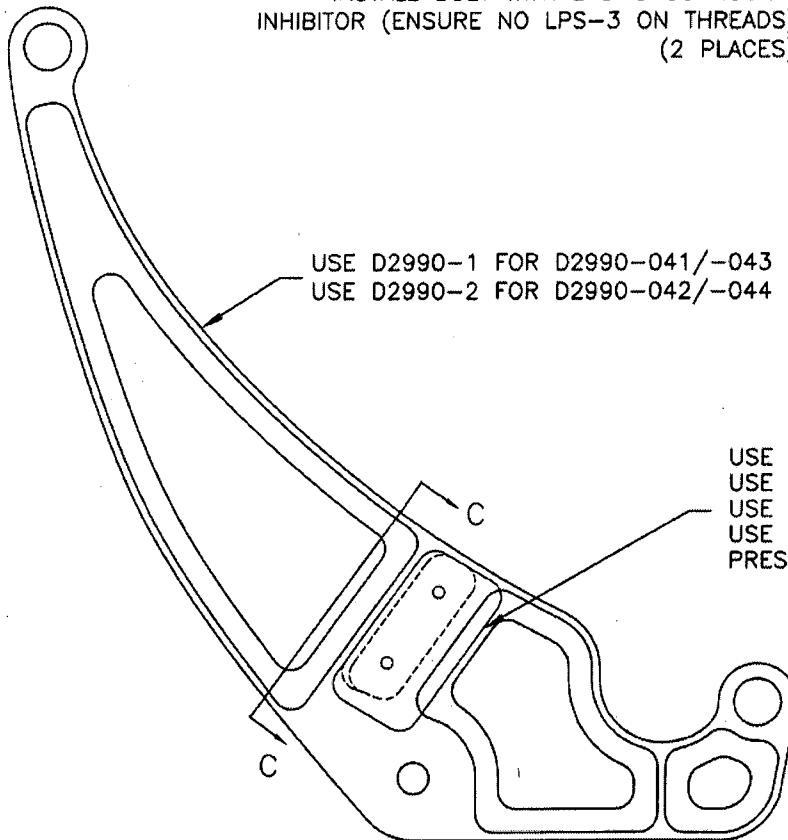
AN3C16A BOLT (1)  
NAS1515H3 WASHER (2)  
MS21043-3 NUT (1)  
INSTALL BOLT WITH LPS-3 CORROSION  
INHIBITOR (ENSURE NO LPS-3 ON THREADS)  
(2 PLACES)



USE D2990-1 FOR D2990-041/-043  
USE D2990-2 FOR D2990-042/-044

SECTION C-C  
SCALE 1:3  
(ROTATED)

USE D2805-1 FOR D2990-041  
USE D2805-2 FOR D2990-042  
USE D2805-3 FOR D2990-043  
USE D2805-4 FOR D2990-044  
PRESS INTO PLACE PRIOR TO POWDER COAT



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NO. 33597

**D2990-041/-043 BRACKET ASS'Y (SHOWN).**  
**D2990-042/-044 BRACKET ASS'Y (OPPOSITE)**

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)  
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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